

Date: Friday, 18/07/2008 1:10:18 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CABIN FLOOR PROTECTOR
Job Number :	40646		
Estimate Number :	12764		
P.O. Number :		Part Number :	D35743
This Issue :	18/07/2008	Drawing Number :	D3574 REV.A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	A
Previous Run :	35864	Material :	
Written By :		Due Date :	31/07/2008
Checked & Approved By :	JUL 08.7.18	Qty:	2
Comment :	Est Rev : A New Issue 07-01-22 EC	Um:	Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MLEXS125F6002904

GE PLASTICS LEXAN SHEET



Comment: Qty.: 33.6000 sf(s)/Unit Total : 67.2000 sf(s)

lexan sheet

Batch: 105330

B 8-7-22

2.0

WATER JET

FLOW WATER JET

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

B 8-7-22

2

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B 8-7-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

S 08/07/23 (42)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAN 08/07/26 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:18 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 40646

Part Number: D35743

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/28 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

1-9/1/28 (2) PPP 40630

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/29

Job Completion



MF 08-07-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 406460
Description: Cabin Floor Protector		Part Number: D3574-3
Inspection Dwg: D3574	Rev: A	Page 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.004/-0.001	1.132	*		Tape measure	
Ø3.00	+0.006/-0.001	3.006	*			
2.00	+/-0.030	2.00	*			
7.37	+/-0.030	7.37	*			
11.00	+/-0.030	11.00	*			
15.25	+/-0.030	15.25	*			
17.50	+/-0.030	17.50	*			
25.87	+/-0.030	25.87	*			
34.94	+/-0.030	34.94	*			
39.75	+/-0.030	39.75	*			
44.75	+/-0.030	44.75	*			
50.87	+/-0.030	50.87	*			
58.38	+/-0.030	58.38	*			
61.25	+/-0.030	61.25	*			
63.43	+/-0.030	63.43	x			
63.50	+/-0.030	63.50	*			
65.25	+/-0.030	65.25	*			
1.25	+/-0.030	1.25	*			
7.50	+/-0.030	7.50	x			
11.87	+/-0.030	11.87	x			
14.75	+/-0.030	14.75				
26.00	+/-0.030	26.00	*			
34.18	+/-0.030	34.18	*			
40.87	+/-0.030	40.87	x			
45.00	+/-0.030	45.00	*			
48.00	+/-0.030	48.00	*			
55.13	+/-0.030	55.13	*			
59.50	+/-0.030	59.50	*			
59.75	+/-0.030	59.75	x			

00/07/03

DART AEROSPACE LTD		Work Order: 4066p
Description: Cabin Floor Protector		Part Number: D3574-3
Inspection Dwg: D3574	Rev: A	Page 2 of 3

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
61.25	+/-0.030	61.25	*		Tape	
61.88	+/-0.030	61.88	*		Tape	
64.63	+/-0.030	64.63	*		Tape	
1.13	+/-0.030	Remove and measure				
3.19	+/-0.030	3.19	*		Tape near	
7.63	+/-0.030	7.63	*			
8.13	+/-0.030	8.13	*			
11.00	+/-0.030	11.00	*			
14.50	+/-0.030	14.50	*			
15.75	+/-0.030	15.75	*			
18.13	+/-0.030	18.13	*			
22.50	+/-0.030	22.50	*			
25.25	+/-0.030	25.25	*			
30.75	+/-0.030	30.75	*			
34.00	+/-0.030	34.00	*			
35.13	+/-0.030	35.13	*			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	40.00	*			
41.50	+/-0.030	41.50	*			
41.88	+/-0.030	41.88	*			
43.63	+/-0.030	43.63	*			
44.60	+/-0.030	44.60	*			
3.63	+/-0.030	3.63	*			
5.94	+/-0.030	5.94	*			
6.75	+/-0.030	6.75	*			
9.50	+/-0.030	9.50	*			
10.38	+/-0.030	10.38	*			
14.50	+/-0.030	14.50	*			

S 02/07/23

DART AEROSPACE LTD		Work Order: 400646
Description: Cabin Floor Protector		Part Number: D3574-3
Inspection Dwg: D3574	Rev: A	Page 3 of 3

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.75	+/-0.030	16.75	*		Tape measure ↓	
18.94	+/-0.030	18.94	*			
19.00	+/-0.030	19.00	*			
24.13	+/-0.030	24.13	*			
33.88	+/-0.030	33.88	*			
35.75	+/-0.030	35.75	*			
36.19	+/-0.030	36.19	*			
39.50	+/-0.030	39.50	*			
40.25	+/-0.030	40.25	*			
43.50	+/-0.030	43.50	*			
43.96	+/-0.030	43.96	*			
46.60	+/-0.030	46.60	*			

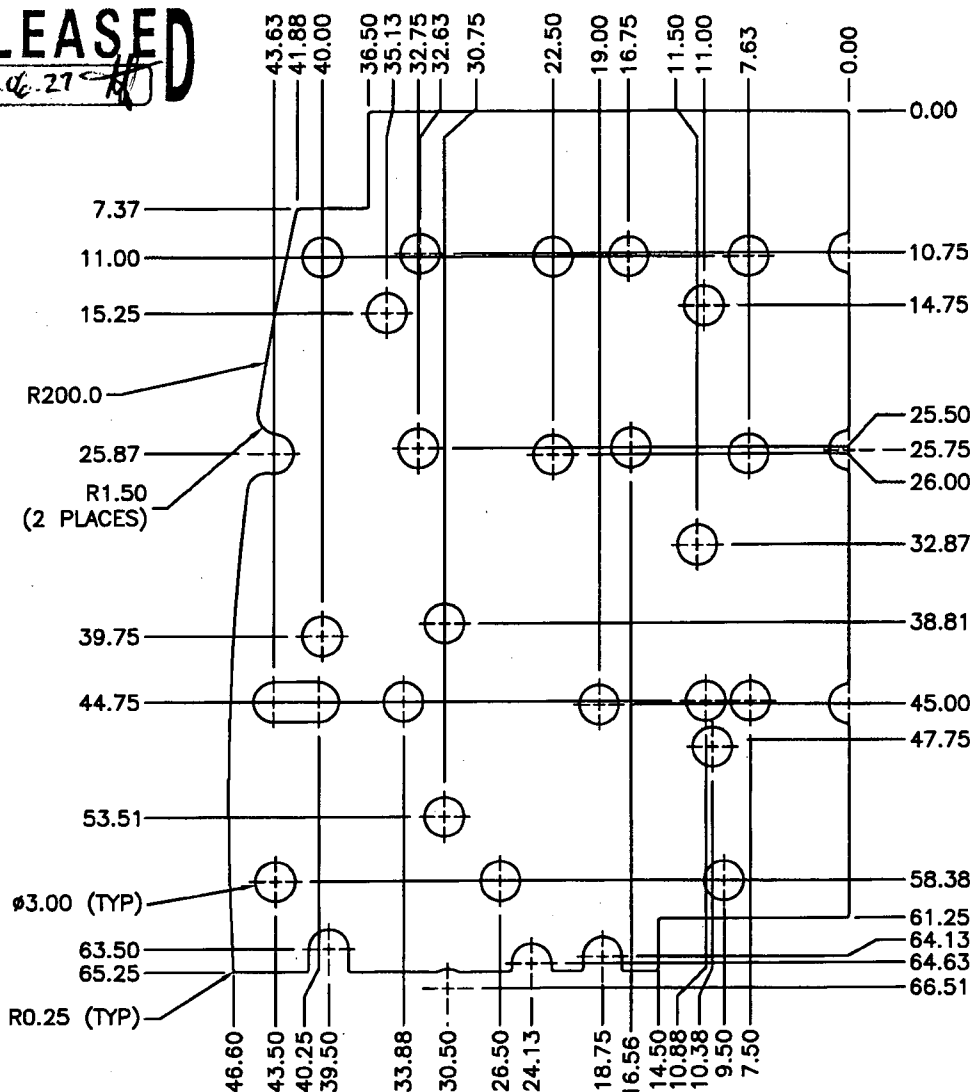
Measured by: TB	Audited by: S	Prototype Approval:	N/A
Date: 8-7-22	Date: 08/07/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	DD



DESIGN CE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27



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D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

NOTES:

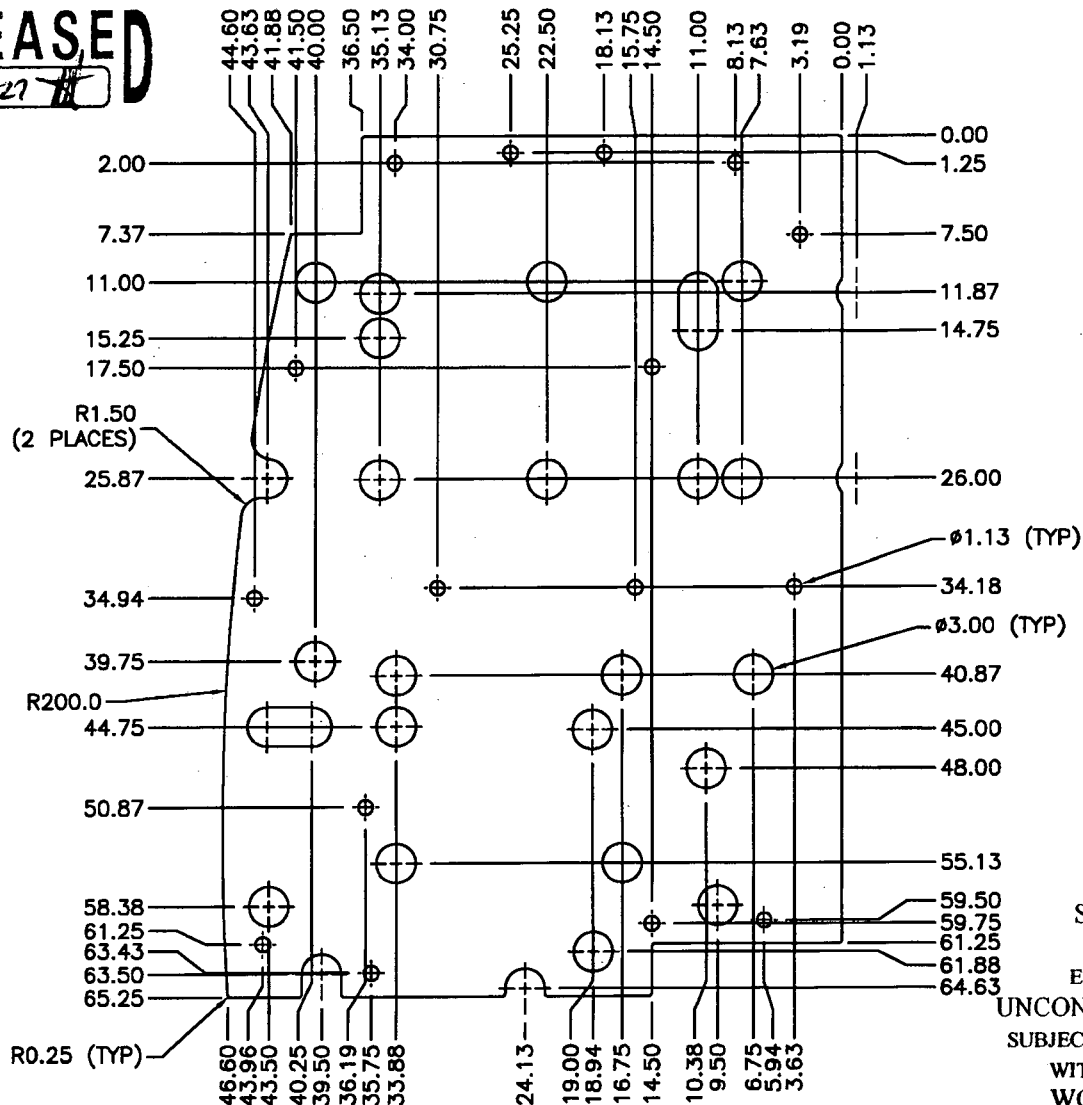
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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D3574-3 CABIN FLOOR PROTECTOR**NOTES:**

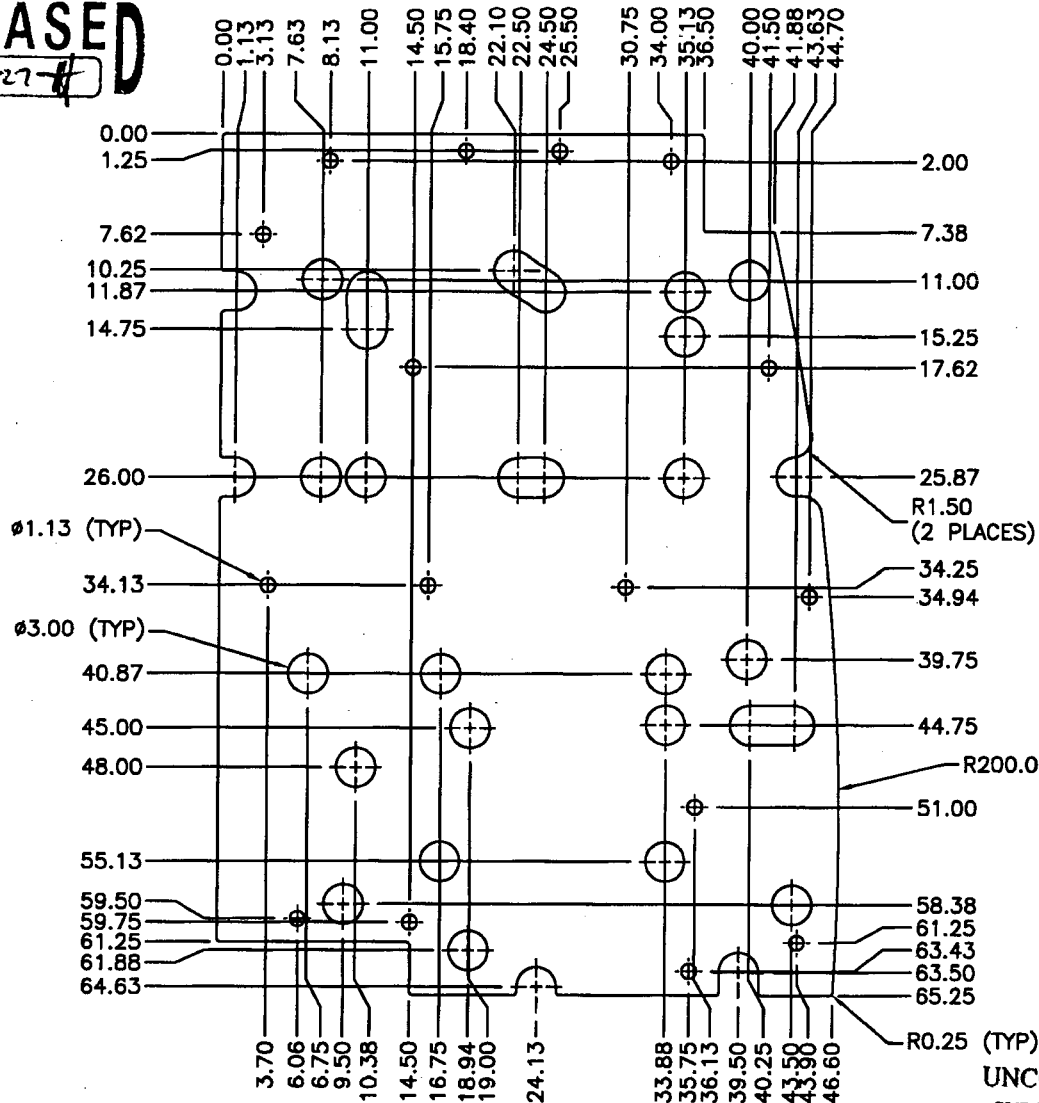
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

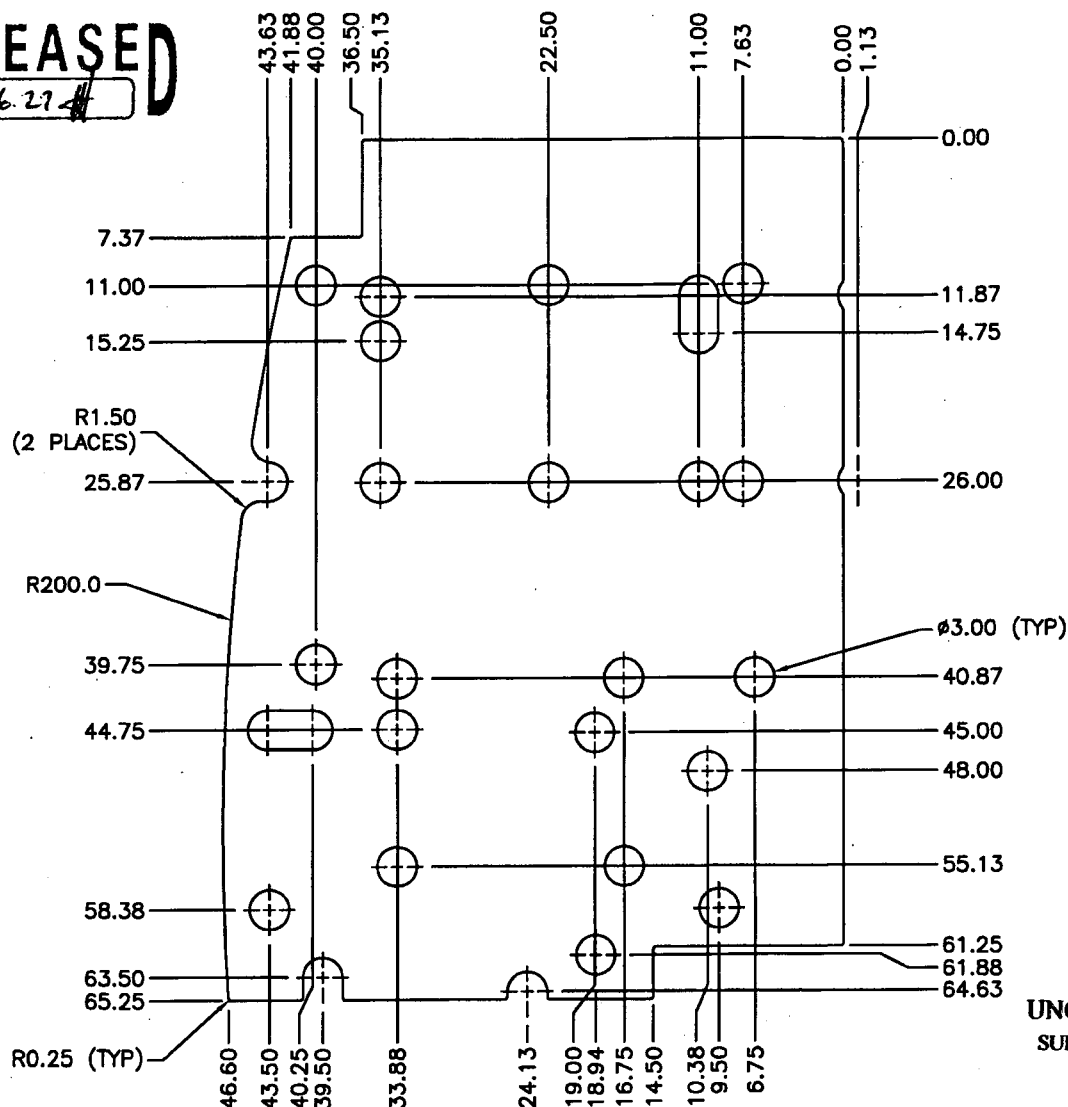
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

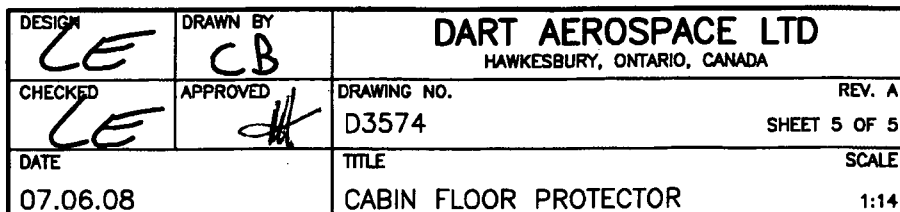
RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

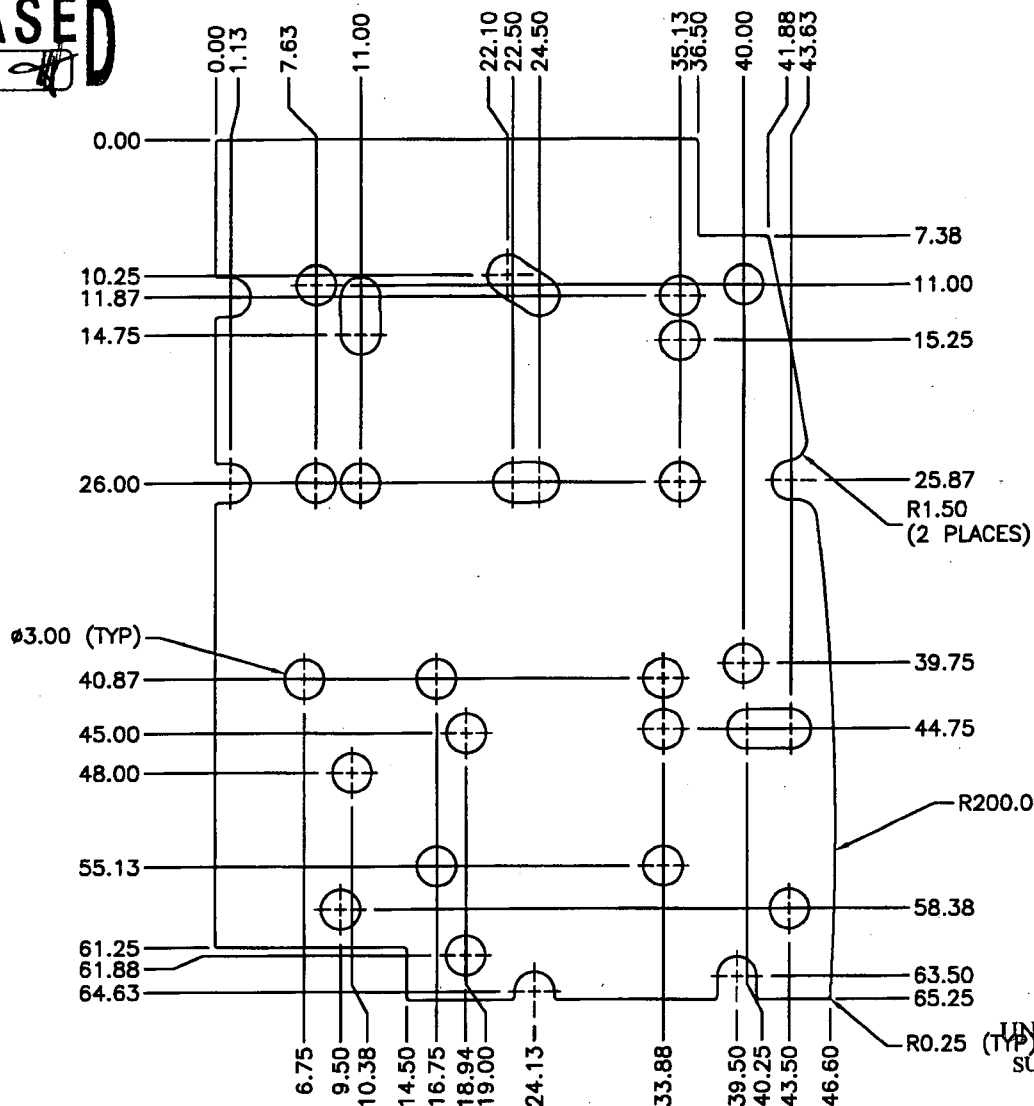
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D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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